

Date: Tuesday, 11/29/2005 6:47:09 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE		
Job Number	: 25033					
Estimate Number	: 10437					
P.O. Number	: N/A		Part Number	: D33191		
This Issue	: 11/29/2005 S.O. No. : N/A		Drawing Number	: D3319 REV. B		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: B		
Previous Run	: N/A		Material	: N/A		
Written By	: See Above User & Date		Due Date	: 12/21/2005 Qty: 20 Um: Each		
Checked & Approved By	: PSL REV B 05/10/14 KS/RC					
Comment	: Created By Auto Work Order					

Additional Product

Job Number:	
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Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING 
Comment: PURCHASING Issue P/O: <u>00000186</u> <u>05/11/30</u> Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3319 Possible Supplier: Industrial Laser Material release note is required		

Tools:

2.0	D33191F	Wearplate 
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 WEARPLATE

Tools:

3.0	PACKAGING 1	PACKAGING RESOURCE #1 
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Comment: PACKAGING RESOURCE #1
 Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached

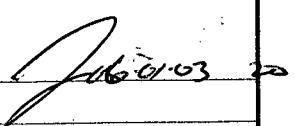
DL 05/12/30 20

Tools:

4.0	QC6	DIMENSIONAL CHECK 
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Comment: DIMENSIONAL CHECK

Tools:

		
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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

V/H

Tools:

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B
 2- Form flat on press using DT8776 block

SB 06/01/05

Tools:

7.0 QC6

DIMENSIONAL CHECK



J06-01-05

Comment: DIMENSIONAL CHECK

Tools:

8.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3
 2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: B

21

Qty	Part Number	Description	Batch
A/R	N/A	7560 Hardcoat Rod	<u>M19682</u>

CPL 06-02-16

Tools:

9.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

1A06/02/16 21

Tools:

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Q.M. 06-03-10

Tools:

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/14
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

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Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MM

06 03 13

(21)

Tools:

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: ST361

PP 9/3/13 (21)

Tools:

13.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Tools:

Job Completion



PP 06/03/14 (21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 82121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(09) 235 6089 / 235 3535 Waikato
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 500321329

CUSTOMER	Wilkinson	SPECIFICATION												CERTIFICATE No					
CUSTOMER ORN	90-21N-288	ASTM A198 CS Type A												TC107797					
MILL ORN	453666	PRODUCT												PAGE					
PACK NUMBER	HEAT No	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N ₂	CE(%)	DIMENSIONS	
R9-455948-00	639184	6	1	20	12	16	12	18	26	4	7	1	1					0.044" x 48" x Coil	
R9-455949-00	639184	6	1	20	12	16	12	18	26	4	7	1	1						
R9-455951-00	638405	5	1	20	13	19	12	19	17	1	5	1	1						
R9-456216-00	638526	6	TR	20	12	18	12	18	18	4	6	1	1						
R9-456217-00	638526	6	TR	20	12	18	12	18	18	4	6	1	1						
R9-456218-00	636939	5	TR	20	12	20	13	17	25	TR	8	1	1						
R9-456219-00	636939	5	TR	20	12	20	13	17	25	TR	8	1	1						

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (B)=50mm	PLASTIC STRAIN RATIO (r) (A)=r0 (B)=r90 (C)=r ² (D)=(r ⁰ +r ⁹⁰ +2r ⁴⁵)/4	IMPACT TEST (A)=r0 (B)=r90 (C)=45	(C)=5mm x 5mm (D)=2.5mm x 10mm (E)=7.5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15	(C)=C+Mn/6+S/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
OC METALLURGIST

18 ga CRms

01/03

100 #186